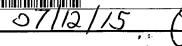
•		•		in the state of th		Dart A	) Aerospac	e Ltd.		_
	sday, 11/29/2007 11: Johnston	11:16 AM	Pr	ocess Sheet		À	Y		5	_
Customer Job Number	: 36063	Dart Helicopters Se	rvices	Drawing Name	: HIGH A	FT X-TUB	E 412			
Estimate Number P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By	: 10559 : : 11/29/2007 : NC : // : 36062	S.O. No. :	IDING GEAR	Part Number Drawing Number Project Number Drawing Revision Material Due Date	er : N/A	64-243 RE	€V D · · Qty:	1 (	Um: E	ach
Checked & Appro	: Es Es Es	t Rev:E 04.02.16 t Rev:F 06-03-29 t Rev:G 06.12.08 t Rev:H 07-04-30	Reformat; Added D Remove Coments per ECN 886 As per Rev D							
Additional Produc	t									
Job Number:										
Seq. #:	Machine Or	Operation:		Description :						
1.0	DC		DOC	CUMENT CONTROL						
· · · · · · · · · · · · · · · · · · ·										
Comm	ent: DOCUMEN	•		D 440 004 000 0110				:		
		bluefile and create		P D412-664-203 CHG	000 0					-
2.0	D6009129		Cros	sstube Material						
Comm	Pick.	0000 Each(s)/Unit		0 Each(s)			.*			
		mber Descriptio 129 Crosstube $\underline{f}$ = 3.500"; ID = 2.25	<u>3 32306</u>		J.F.	07/	112/16	2	0	)
3.0	MORI SEIKI		МОР	RI SEIKI CNC LATHE LARO	3E			j.	* . * .	
Comm	ent: MORI SEI	(I CNC LATHE LA	RGE					<u> </u>		
	1-Fill tube	with sand & install	olugs DT8534 on b	ooth ends as per Folio	FA166	ar.				
÷ .*	2-Turn first	side as per Folio F	FA166	 •	J.F.	07	1/2/1	5	(1	)
•	3-Deburr &	Inspect for surface	damage. Repair	damage within limits a	as per Dwg D4	12-664-2	43.		Ů	-

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET





4.0

QC1

<b>W</b> /O:			WORK ORDER	CHANGES				te.
DATE	STEP	PROCE	EDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:	PAR #:	Fault Category:	NCR: Ye	es No <b>DQ</b>	A:	Date: _	
				QA	: N/C Close	ed:	Date: _	<u> </u>
NCR:		WC	ORK ORDER NON-CON	FORMANCE (N	CR)			
			Corrective Actio	n Section B				1

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annessal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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Thursday, 11/29/2007 11:11:16 AM Date: User: .Kim Johnston **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664203 Job Number: 36063 Job Number: Description: Seq. #: Machine Or Operation: MORI SEIKI CNC LATHE LARGE 5.0 MORI SEIKI Comment: MORI SEIKI CNC LATHE LARGE 1-Turn second side as per Folio FA166 2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243. J.F. 07/12/15(1) 3- Remove sand and plugs 4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243 Inside of Cuff(Donot engrave on outside of tube) INSPECT ALL DIM TO DIM SHEET 6.0 QC1 Comment: INSPECT ALL DIM TO DIM SHEET SECOND CHECK 7.0 QC8 Comment: SECOND CHECK LANDING GEAR RESOURCE 1 8.0 LANDING GEAR 1 Comment: LANDING GEAR RESOURCE 1 AWM 07-12-18 1-Polish entire outside surface of crosstube INSPECT WORK TO CURRENT STEP QC5 9.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 10.0 HAND FINISHING Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 11.0 QC3 Comment: Inspect work & Chemical conversion Coat

### Dart Aerospace Ltd

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B				T		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval  Chief Eng	Approval QC Inspector		
				Marian Marian Tanan		. ,				
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Date: Thursday, 11/29/2007 11:11:17 AM User: Kim Johnston **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664203 Job Number: 36063 Job Number: Description: Seq. #: **Machine Or Operation:** BENDING MACHINE 12.0 Comment: BENDING MACHINE Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010 13.0 **CHECK OF X-TUBES** LANDING GEAR RESOURCE 1 14.0 LANDING GEAR 1 Comment: LANDING GEAR RESOURCE 1 517 1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 8-1-3 2-Ream hole to finish size in tube as per Dwg D412-664-243using drill Jig DT8550 & DT8551.Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243 — AVM - 07-03 HAND FINISHING RESOURCE #1 15.0 HAND FINISHING1 ANM 08-01-04 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 16.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION . 17.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP **OUTSIDE SERVICES -LG** 18.0 Comment: Sub-Contracting OUTSIDE SERVICES Liquid Penetrant Inspection as per QSI 038Or CZ08/01/04 D Issue P/O: 5362 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CH	IANGES	-			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				QA: N	/C C	losed:	Date: _	

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		Description of NC		Corrective Action Section B		Verification	Ammraus	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, 11/29/2007 11:11:17 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Job Number: 36063 Part Number: D412664203 Job Number: Description: Seq. #: Machine Or Operation: PACKAGING RESOURCE #1 PACKAGING 1 19.0 Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order. QC5 · 20.0 Comment: Inspect for damage & ensure results are as per Dwg D412-664-203 SPRAY PAINTING 21.0 Comment: SPRAY PAINTING 1-Prime inside and outside crosstube as per QSI 005 4.2 08-01-08 2-Paint outside crosstube with White Imron as per QSI 005 4.2 INSPECT SPRAY PAINT 22.0 QC14 Comment: Inspect Spray Paint Wrap in plastic bag to protect from scratches D3595 23.0 0.0492 sf(s)/Unit Total: Rubber Cushion (per sq ft) .630" x5.70" x2pcs Batch: 33835 28 08-01-24 24.0 D2856600 Abrasion Strip Comment: Qty.: 1.7640 f(s)/Unit Total: 1.7640 f(s) Pick: Description Batch Qty Part number 08-01-24 2 D2856-600(Cut to 10.090") Abrasion Strip D28961 25.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part number **Description Batch** 3020010-80 Support 1 D2896-1

# Dart Aerospace Ltd

W/O:		WORK ORDER CI					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	PAR #:	_ Fault Category:	NCR: Yes No	DQA:	Date: <u> </u>
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng		
08.01.0ª	210	Paint is thin on one sich of the Lise.	051012	Scuff entire trize, and re-spray white per as 1005	-09 -09	ac/olos	Josiwa	NE-01-09.	

Thursday, 11/29/2007 11:11:17 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664203 Job Number: 36063 Job Number: Description: Seq. #: **Machine Or Operation:** Chafing Shield 26.0 D31891 Comment: Qty.: Total: 2.0000 Each(s) 2.0000 Each(s)/Unit Pick: Qty Part number **Description Batch** 36065 08-01-24 Chafing Sheild 2 D3189-1 11 Clamp(per MIL-DTL-8783C) MS2192028 27.0 4.0000 Each(s)/Unit 4.0000 Each(s) Comment: Qty.: Total: Pick: **Description Batch** Qty Part number Clamp 104423 4 MS21920-28 0124 clamp(per MIL-DTL-8783C) 28.0 MS2192030 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) clamp(per MIL-DTL-8783C) 21 08-01-24 batch: 106 810 LANDING GEAR RESOURCE 1 29.0 LANDING GEAR 1 Comment: LANDING GEAR RESOURCE 1 Assemble as per Dwg D412-664-203 1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs 08-01-24 Batch: 106 695 6398 Magnobond **A/R** Expiry Date: 08-(1-6) 08-01 ~28 2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb. INSPECT WORK TO CURRENT STEP 30.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 31.0 Comment: PACKAGING RESOURCE #1 Pick Packing Kit

Dart Ae	rospace Li	td						
W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					QA: N	/C Closed:	Date: _	
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		Description of NC		Corrective Action Section	n B	Verification	Ammerical	A1
DATE	STEP	Section A	Initial Chief Eng	Action Description	Sign &	Section C	Approval Chief Eng	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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	Johnston	2007 11:11:17 AM	Process Sheet	
Customer:	CU-DAR001	Dart Helicopters Services		ame: HIGH AFT X-TUBE 412
Job Number:	36063		Part Nun	nber: D412664203
Job Number:				
Seq. #:		r Operation:	Bolt	Description :
32.0	AN640A		DUIL	
Comme	-	6)	M106514 (X)	
33.0	AN641A		Bolt	
Comme	ent: Qty.: Bolt Batch:/	2.0000 Each(s)/Unit To	otal : 2.0000 Each(s)	M
34.0	AN960JD616		Washer	
Comme	nt: Qty.: 1 Washer Batch:	18.0000 Each(s)/Unit To	otal : 18.0000 Each(s)	Pu
35.0	MS21042L6		Nut	
Comme	nt: Qty.: Nut Batch:		otal : 6.0000 Each(s)	28/2/01 (1)
36.0	QC4		INSPECT 100% KÌTS FOF	
37.0	nt: INSPECT	T 100% KITS FOR COMF	PLETENESS , PACKAGING RESOURCE	#1000100101
			TAGA GALAGA	
Comme		SING RESOURCE #1 and pack for shipping as p	er PPP D412-664-203	
	******Ens	ure tube is not packaged	if curing time is less than 12 hrs	s, see step 27 for application time & date
	Time & d	ate of packaging:	22 8/2/1	54 P
	Location: PPP Rev			

Dart Ae	rospace L	td							•
N/O:			W	ORK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<u> </u>			
Part No	•	PAR #:	Fault Cate	egory: N	CR: Yes	No <b>DQ</b>	A:	Date:	
					QA: N	C Close	d:	_ Date: _	
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DATE	OTED	Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector

Date:

Thursday, 11/29/2007 11:11:17 AM

User:

Kim Johnston ...

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Part Number: D412664203

Job Number: 36063

Job Number:

Seq. #:

Machine Or Operation:

Description:

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



vi 2008/2/04



Dart Ae	rospace Li	td					·			
W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			ż							
Part No	•	PAR #:	Fault Cat	egory:	NC	R: Yes	No <b>DQ</b>	A:	_ Date: _	
						QA: N	/C Closed	d:	_ Date: _	
NCR:			WORK ORI	DER NON-CONFO	RMANCE	(NCR	<b>(</b> )			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B tion	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector

DART AEROSPACE LTD	Work Order:	36063
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwa: D412-664-243 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

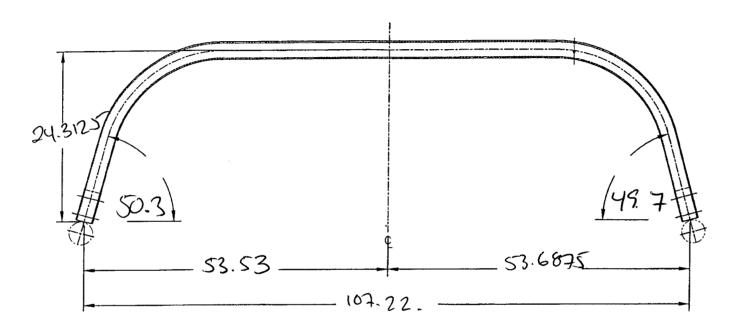
	spection Sheet	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		0.00=/.0.000	<del> </del>				*****
	2.684	+0.005/-0.000	2.687	سبب			
	2.748	+0.005/-0.000	2.752			-	
	2.884	+0.005/-0.000	2.889"	1			
	3.019	+0.005/-0.000	3024"	0			
	3.163	+0.005/-0.000	3.168"				
	3.308	+0.005/-0.000	3,3/2"	<u></u>	ł		
<	3.429	+0.005/-0.000	3,432				
SIDE	2.990	+0.005/-0.000	2, 995"				
S	2.618	+0.005/-0.000	2,622.				
	0.200	+/-0.010	200''				
	R0.063	+/-0.010	B0.063"				
	R0.500	+/-0.010	B0.500'				
	4.971	+/-0.030	4,987"				
	2.684	+0.005/-0.000	2.689				
	2.748	+0.005/-0.000	2, 753"				
	2.884	+0.005/-0.000	2,889"		/		
	3.019	+0.005/-0.000	3,0241		1		
	3.163	+0.005/-0.000	3.166"				
	3.308	+0.005/-0.000	3,3/0"				
<u>m</u>	3.429	+0.005/-0.000	3,430"		·		
SIDE	2.990	+0.005/-0.000	2,997"				
S	2.618	+0.005/-0.000	2.622"				
	0.200	+/-0.010	<i>-</i> ک00′				
	R0.063	+/-0.010	R0,063"		,		
	R0.500	+/-0.010	Ro 500'	1//			
	4.971	+/-0.030	4.972'				
	124.09	+/-0.020	124.110"				

	77 77 77		
Measured by: J. F.	Audited by:	Prototype Approval: N/A	
Date: 07/12//2	Date: 07/12/17	Date: N/A	

Rev	Date	Change	Revised by Approved
Α	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM
В	06.03.09	Dwg Rev updated	KJ/JLM
С	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM 🛠 🔀

DART AEROSPACE LTD	Work Order:	36063
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Co	mments	
QC15 Inspection	2	
Date	1801.03	

Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM LA	1
В	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM 🚓	fr



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	DESIG	PH	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
T	CHECK	(ED	APPROVED #//	DRAWING NO. REV. D
1		9)	4	D412-664-243 SHEET 1 OF 3
T	DATE		· · · · · · · · · · · · · · · · · · ·	TITLE SCALE
1	07.0	3.09		CROSSTUBE ASSEMBLY (412 HI AFT) NTS
	Α		01.10.17	NEW ISSUE
	В		05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES
	С		06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30
Ī	D		07.03.09	REMOVE D2732-058, CHANGE TO

D3595-063-570

SHOP COPY

RETURN TO

ENGINEERING

WORK ORDER

3606

07.04.24

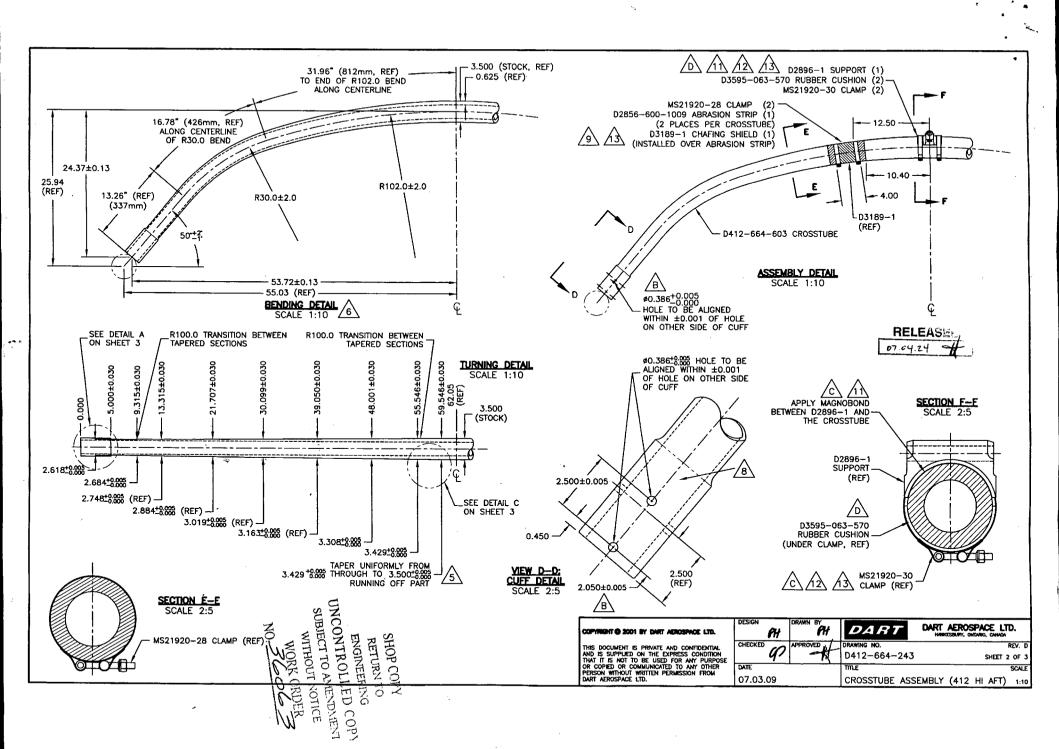
Qty	Part Number	Description
Х	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

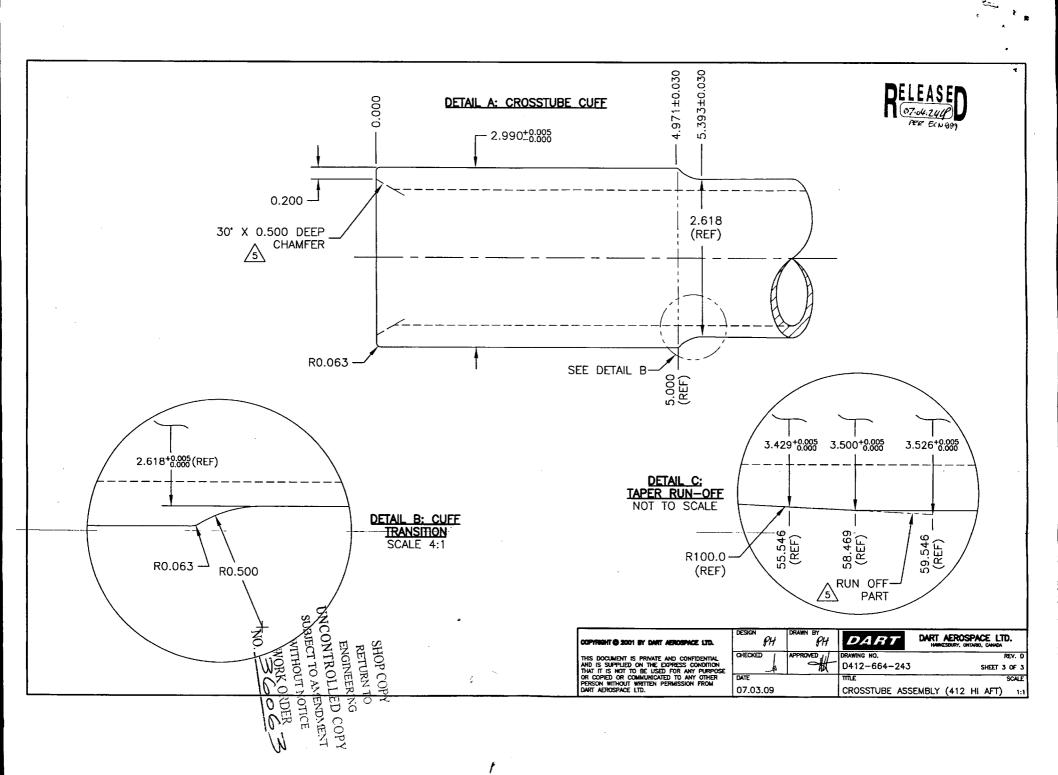
### **GENERAL NOTES:**

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129 FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART 005 4.2
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING UNCONTROLLED COPY STYLUS. INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE SUBJECT TO AMENDMENT OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE **UNACCEPTABLE**
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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# LIQUID PENETRANT TEST REPORT

P - 8-1202

ACUI	/E14													D	AGE	1	1	OF 1	
CLIENT		DART AREOSP	PACE				DATE			JAN. 4	4, 200	8			ME	AM			<b>-</b>
OLIEN! ATTENTION		LINDA LACELL					ACURE	N JOB	No.	188-8-	·			_					
ADDRESS	l	1270 ABERDEE		KESBURY O	NT		POW												
ADDRESS		1270 ABENDEL		NEODOINI O			Work		ION	HAWK	(FSBI	JRY							
	-						_			ASTM			138	R	EV./DA	TE 20			
						E V TUD	-	TANCE	310.	ASTIVI	1417.	/031-0		'`	EV./D/				
PROJECT		206B AFT X-TU				X-10B	E 412												<del></del>
ITEM(S) EX	AMINED	JOB#'S 36051,	36052, 3605	4, 36060, 360	)63 														
JOB DES	CRIPTIC	N	PROCEDU	RE NO. LT-0	0002 REV	/./DATE			Т	ECHNIQU	JE <b>N</b> O	. LT-	-0002-0	2 R	EV./DA	TE			
Part No.	D20666	7201, D2066671	03, D41266	4203			Materi	al ,	ALOD	YNED A	LUMI	NUM	7	hickn	ess				
Scope		LOURESCENT			INSPE	CTION	CARRI	ED O	UT O	N 100%	6 OF	EXTE	ERNAL	SUF	RFACI	Ξ.			
							·							-					
Teas De											====								
TEST DE	TAILS	⊠ Eluc	prescent	п	Visible		☑Wat	er Wa	sh			Solve	ent Rer	novab	le	□ Po	ost En	nulsifi	ied
Family Bra	nd M	IAGNAFLUX	rescent		VISIDIC		Black			8178			t > 100				mbier		
Penetrant		L67	Minimun	n Dwell time	45	Min.	Lightir			<u>TFlashlig</u>					<b></b> ☑Outp	ut>100	fc @ s	surfac	:e
Penetrant				n Dry time	>10	Min.	Other								2 ( 5	- 5-4-		<u> </u>	
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	: // Type : LANDING GEAR : 36062	Material :	· <del>-</del>	
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Comment	: Est Rev:E 04.02.16 Reformat; Added D3			
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	1-Fill tube with sand & install plugs DT8534 on b	oth ends as per Folio FA16	BEEE.	_
			- CHI	ENCE ON
	2-Turn first side as per Folio FA166			ENCE ONLY
	3-Deburr & Inspect for surface damage. Repair of	damage within limits as pe		
4.0		ECT ALL DIM TO DIM SHEET		
4.0				
	THE MODE OF ALL DIM TO DIM OUT IT			
Comme	nt: INSPECT ALL DIM TO DIM SHEET			